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**D3290-041**  
**Job Sheet 190761**



**Part No:** D3290-041

**Job Qty:** 4 pcs

**Part Name:** Replacement Exterior Window For -111



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/14/19

**Job Tracking No:**

**Created By:** Marie Lajeunesse

**Due Date:** 3/22/19

**Description:** SIOP

**Type:** Stock

**Note:** DWG REV C IPP B 05.05.25 Added Step 11 KJ/JLM IPP C IPP Rev:D Now on Waterjet 06-06-16 JLM IPP rev E rev C dwg 07.09.28 EC verified by: DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off          |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                   |
| 100   | Small Fab - 1               | 4 pcs | 3/22/19    |          | 0.00      | 1.72    | Small Fab - 1         |           | SAP<br>19-04-12   |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                   |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                   |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                   |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                   |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                   |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                   |
| 170   | QC 5                        | 4 pcs | 3/22/19    |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>40<br>9-89 |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 42             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                   |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                   |
| 180   | Packaging 3-1 - Stock - B4B | 4 pcs | 3/22/19    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |                   |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                   |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                   |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |                   |
|       |                             |       |            |          |           |         | Packaging 3 - 5 - B4B |           |                   |
|       |                             |       |            |          |           |         | Packaging 3 - 6 - B4B |           |                   |

Plex 2/14/19 11:34 AM Dart.lajeunesse.marie

|                |       |         |           |  |                        |             |
|----------------|-------|---------|-----------|--|------------------------|-------------|
|                |       |         |           |  | Packaging 3 - 7 - B4B  |             |
|                |       |         |           |  | Packaging 3 - 8 - B4B  |             |
|                |       |         |           |  | Packaging 3 - 9 - B4B  |             |
|                |       |         |           |  | Packaging 3 - 10 - B4B |             |
|                |       |         |           |  | Packaging 3 - 11 - B4B |             |
|                |       |         |           |  | Packaging 3 - 12 - B4B |             |
|                |       |         |           |  | Packaging 3 - 13 - B4B |             |
|                |       |         |           |  | Packaging 3 - 14 - B4B |             |
|                |       |         |           |  | Packaging 3 - 15 - B4B |             |
|                |       |         |           |  | Packaging 3 - 16 - B4B |             |
|                |       |         |           |  | Packaging 3 - 17 - B4B |             |
|                |       |         |           |  | Packaging 3 - 18 - B4B |             |
|                |       |         |           |  | Packaging 3 - 19 - B4B |             |
|                |       |         |           |  | Packaging 3 - 20 - B4B |             |
|                |       |         |           |  | Packaging 3 - 21 - B4B |             |
|                |       |         |           |  | Packaging 3 - 22 - B4B |             |
|                |       |         |           |  | Packaging 3 - 23 - B4B |             |
|                |       |         |           |  | Packaging 3 - 24 - B4B |             |
|                |       |         |           |  | Packaging 3 - 25 - B4B |             |
|                |       |         |           |  | Packaging 3 - 26 - B4B |             |
|                |       |         |           |  | Packaging 3 - 27 - B4B |             |
|                |       |         |           |  | Packaging 3 - 28 - B4B |             |
|                |       |         |           |  | Packaging 3 - 29 - B4B |             |
|                |       |         |           |  | Packaging 3 - 30 - B4B |             |
|                |       |         |           |  | Packaging 3 - 31 - B4B |             |
|                |       |         |           |  | Packaging 3 - 32 - B4B | DAS         |
|                |       |         |           |  | Packaging 3 - 33 - B4B | 21          |
|                |       |         |           |  | Packaging 3 - 34 - B4B | 9-39        |
|                |       |         |           |  | Packaging 3 - 35 - B4B |             |
|                |       |         |           |  |                        | APR 12 2019 |
| 190 QC 21 - SA | 4 pcs | 3/22/19 | 0.00 0.00 |  | QC 21 - SA - 21        | DAS         |
|                |       |         |           |  | QC 21 - SA - 70        | 21          |
|                |       |         |           |  | QC 21 - SA - 53        | 9-39        |

Part Op 100 - (Small Fab) \*\*\*Windows need to be protected at all time\*\*\* \*\*DEBURR EDGE LIGHTLY\*\*\* Assemble as per Dwg  
 Descriptions: D3290 VERIFY BY: \_\_\_\_\_ DATE: \_\_\_\_\_ Clean D3290-041, wrap in foam wrap and place in plastic  
 wrap \*\*\*Inspection complete D2126 length of material needs to be check for any deformations, material build ups or issue  
 that will lead to any rejections\*\*\*

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

190 - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item | Component Name               | Quantity            | Operation         | Container |
|-------------|------------------------------|---------------------|-------------------|-----------|
| D2126       | Locking Seal (Sold Per Foot) | 13.4 26 ft (6.5 ea) | 100-Small Fab - 1 | 5107093   |
| D3290-1     | Frame                        | 2.4 Ea (1 ea)       | 100-Small Fab - 1 | 5156329   |
| D3290-3     | Window                       | 2.4 pcs (1 ea)      | 100-Small Fab - 1 | 5142079   |

### Job Allocations

| Operation         | Component Part | Required | Inventory | Allocated |
|-------------------|----------------|----------|-----------|-----------|
| 100-Small Fab - 1 | D2126          | 26       | 408       | 0         |
|                   | D3290-1        | 4        | 10        | 0         |
|                   | D3290-3        | 4        | 17        | 0         |

### Part Specifications

Specifications could not be found.



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        |              |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |

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AEROSPACE

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Container No: S172168

Part: D3290-041

Job No: 190761

Serial No/Batch: S172168

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/12/19